










Work Order ID 58237

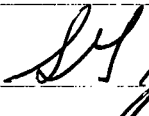
Friday, April 30, 2010 1:01:31 PM

Page 1

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	4/30/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/21/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>10-4-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
100	Weld per dwg A/R S.S. rod Batch: <u>M113328</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble ribs , weld as per dwg D3913								
	inspect before welding mesh								
	2- tack weld mesh on basket as per dwg D3913								
	3- weld hinge (3) and Mounting brackets as per dwg D3913								
	take lid to locate hinge and bracket								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

SL 10/05/04 
PL 10.05.04

D 10.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58237

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Page 2

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Long Basket Base Assembly, 350				Stop	
Start Date:	4/30/2010	Start Qty:	1.00			
Required Date:	5/21/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	Plug holes and mask only interior of hinge (3) prior to powder coat								

1ST COAT:
 START TIME: 1:00pm
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 1:30pm
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME: 1:30pm
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 2:00pm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58237

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8/5 10/05/04

⑩

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

Pick Kit

8/5 10/05/04 ⑩

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/5 10/05/04

⑩

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Friday, April 30, 2010 1:01:31 PM



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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Memo

0.00

Packaging

0.00

EP 10/05/04 @

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/05/04 JF
MF
10-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, April 30, 2010 1:01:30 PM

Page 1

Work Order ID: 58237

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010


Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC



IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-10A		Purchased	No			150	Each	112.0000	6			
												
Bolt												

Location	Loc Qty	Loc Code
ST351	112	
111119	12	
114330	100	

AN960JD8		Purchased	No			150	Each	0.0000	2			
												
Washer												
D2581		Manufactured	No			100	Each	27.0000	2			
												
Mounting Bracket												


WAS 1149'DN 8325

AW 885017

M114343


6 SB 10/05/04
2 SB

Location	Loc Qty	Loc Code
WA	27	
46086	2	
51745	2	
57185	23	

D2931		Manufactured	No			150	Each	872.0000	2			
												
Bumper												

2x
10/05/03

Location	Loc Qty	Loc Code
ST504	872	
46064	872	

D3913-1		Manufactured	No			100	Each	0.0000	1			
												
Rib												

2 SB
B58124 ① 10/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, April 30, 2010 1:01:30 PM

Page 2

Work Order ID: 58237

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 4/30/2010

Required Date: 5/21/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

✓ D3913-15

Wide Handle Plate

Location Loc Qty Loc Code

WA

2

57079

2

100

Each

7.0000

1

①

SY 10/05/03

✓ D3913-3

Rib

Location Loc Qty Loc Code

WA

7

57609

1

58126

6

100

Each

0.0000

2

①

B58127 ② SY 10/05/03

✓ D3913-7

Rib

✓ D3913-9

Hinge Rib

Location Loc Qty Loc Code

WA

1

57610

1

100

Each

0.0000

2

B37610 ① SY 10/05/03

✓ D3916-041

Rib Assembly

B58129 ② SY 10/05/03

Friday, April 30, 2010 1:01:30 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

Work Order ID: 58237

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 4/30/2010

Required Date: 5/21/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

✓ D3916-5



Light Rib

Manufactured

No

100

Each

2.0000

3



B58131 ③ SY 10/05/03

Location

Loc Qty

Loc Code

WA

2

57023

2

✓ D4016-1



Hinge Half, Base

Manufactured

No

100

Each

4.0000

3



SY 10/05/03

Location

Loc Qty

Loc Code

ST109

4

57611

4

✓ D4017-7



Rib

Manufactured

No

100

Each

0.0000

1



B58133 ① SY 10/05/03

✓ D4017-9



Rib

Manufactured

No

100

Each

0.0000

2



B58134 ② SY 10/05/03

✓ D4020-1



Mesh (350 Basket Long, Base)

Manufactured

No

100

Each

0.0000

1



B58135 ① SY 10/05/03

* D4020-11



End Mesh, Basket

Manufactured

No

100

Each

1.0000

2



B58136 ② SY 10/05/03

Location

Loc Qty

Loc Code

WA

1

56990

1

Friday, April 30, 2010 1:01:30 PM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 4/30/2010

Required Date: 5/21/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
✓ D4021-1 Handle Plate		Manufactured	No			100	Each	7.0000	3			
				<u>Location</u>				<u>Loc Qty</u>				
				ST109				7				
					57086			7				
D4021-5 Blanking Plate		Manufactured	No			150	Each	4.0000	2			
				<u>Location</u>				<u>Loc Qty</u>				
				ST109				4				
					57612			4				
✓ D4034-041 Aft Upper Rib Assembly		Manufactured	No			100	Each	4.0000	1			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				4				
					57988			4				
✓ D4034-043 Fwd Upper Rib Assembly		Manufactured	No			100	Each	4.0000	1			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				4				
					58040			4				

B58139 ③ SY 10/05/

2 SB 10/05/04

SY 10/05/03

①

SY 10/05/03

①

Friday, April 30, 2010 1:01:30 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58237

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010


Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20600-AD4W3		Purchased	No			150	Each	1,891.000	2			
												
Cherry Rivets												


Location	Loc Qty	Loc Code
ST321	1891	
106375	3	
107939	888	
111636	1000	

2 SB 10/05/04

MS21042L3		Purchased	No			150	Each	1,816.000	6			
												
Nut												

Location	Loc Qty	Loc Code
ST300	1816	
113537	20	
113644	796	
114523	1000	

6 SB 10/05/04

NAS1149F0332P		Purchased	No			150	Each	959.0000	12			
												
WASHER												

Location	Loc Qty	Loc Code
ST275	959	
18057	959	

12 SB 10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

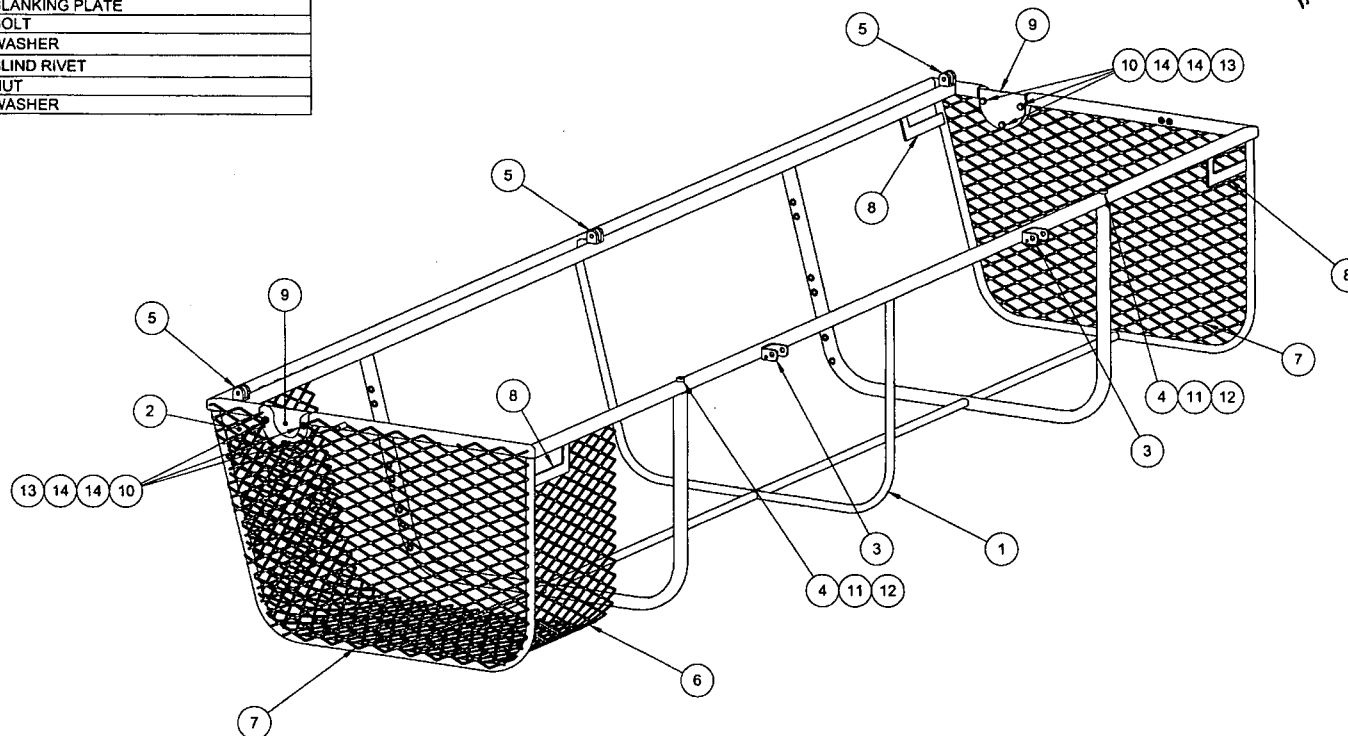
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN980JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D
D8-2 C
D4020-1
MESH

D3913-101
TUBULAR ASSY

#58237

30.00

34.50

2 PL

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL (8)

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
3 PL

3 PL

0.75

A

45.94

45.94

B

D4021-1
HANDLE PLATE

D4021-1
HANDLE PLATE
2 PL

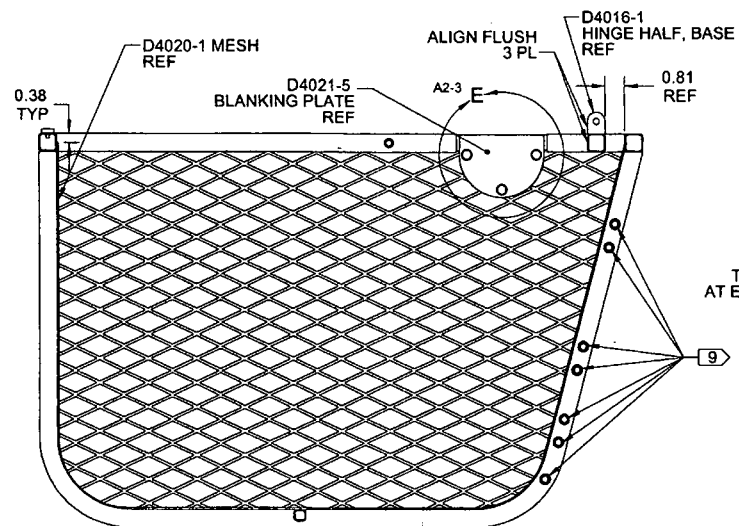
C7-3 A

C3-3 B

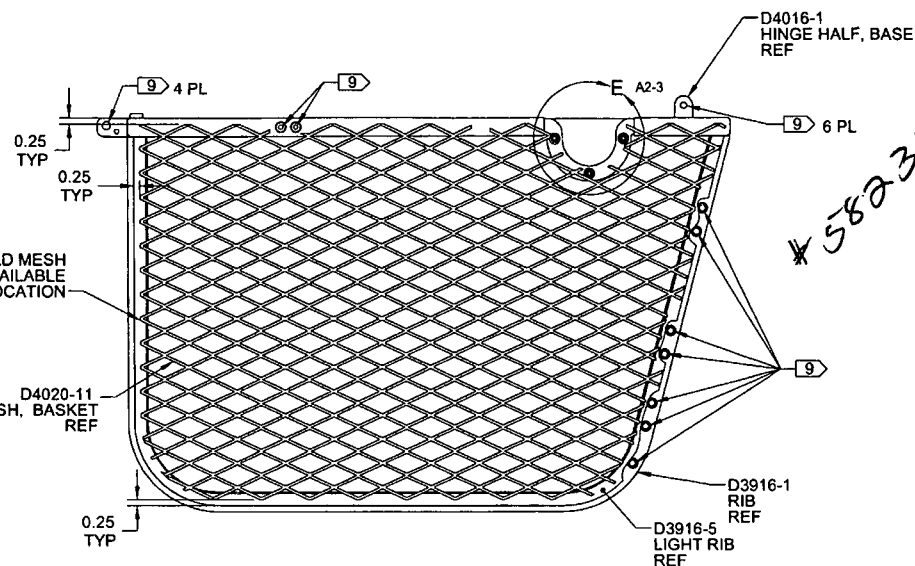
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

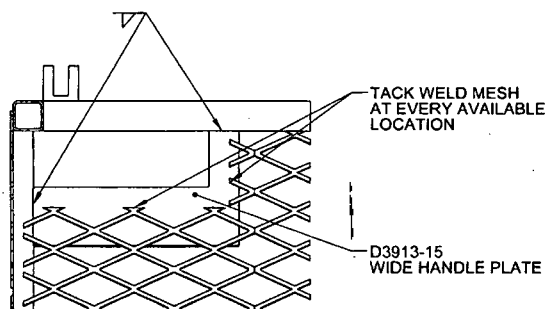
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3913	SHEET 2 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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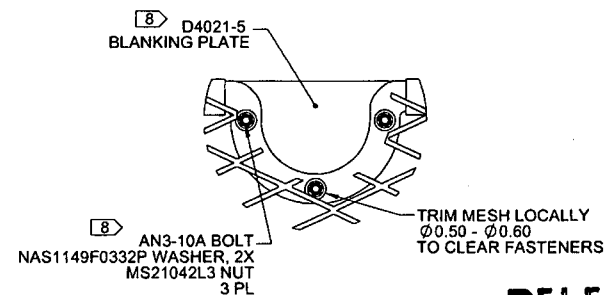
SECTION A-A A5-2







VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

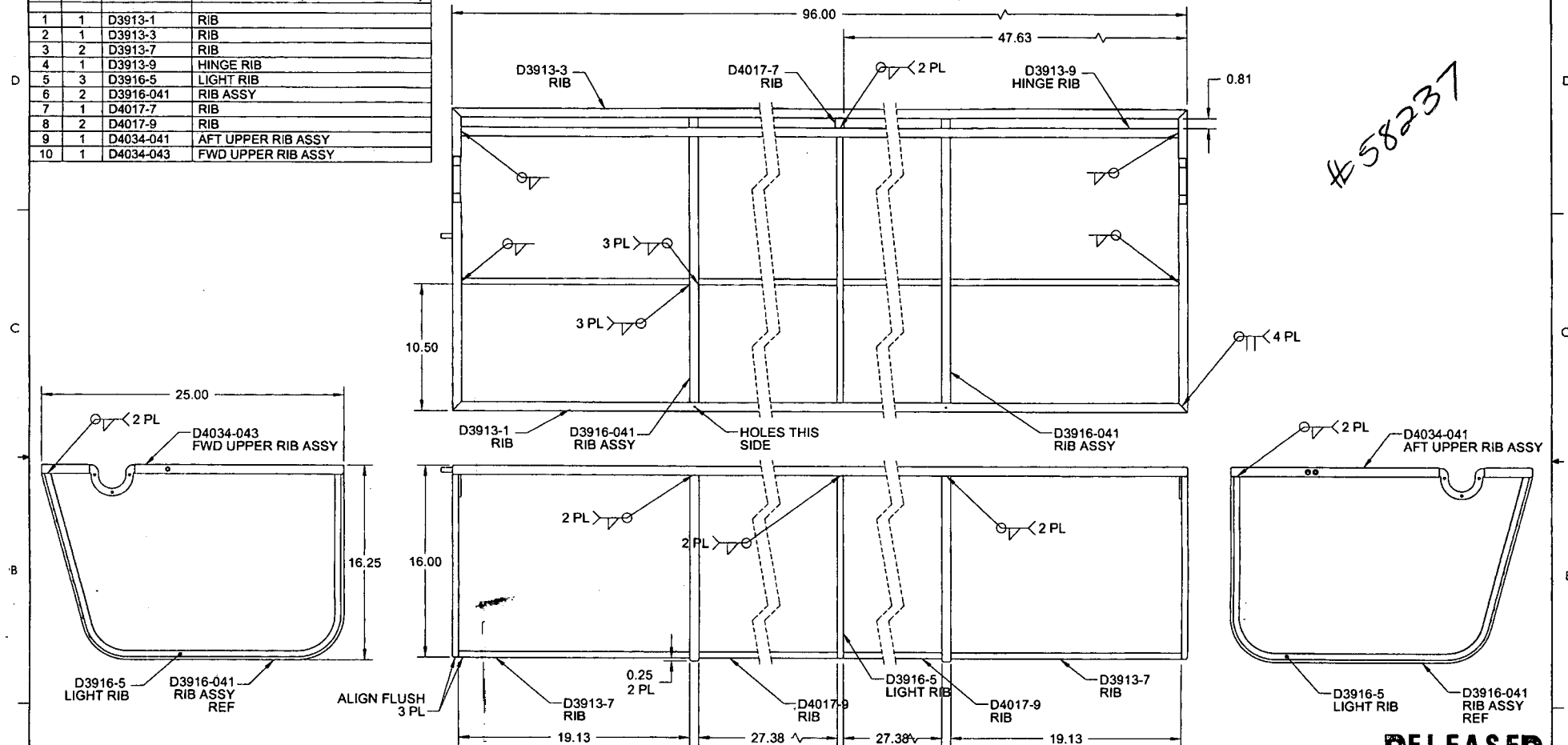


DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-22

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



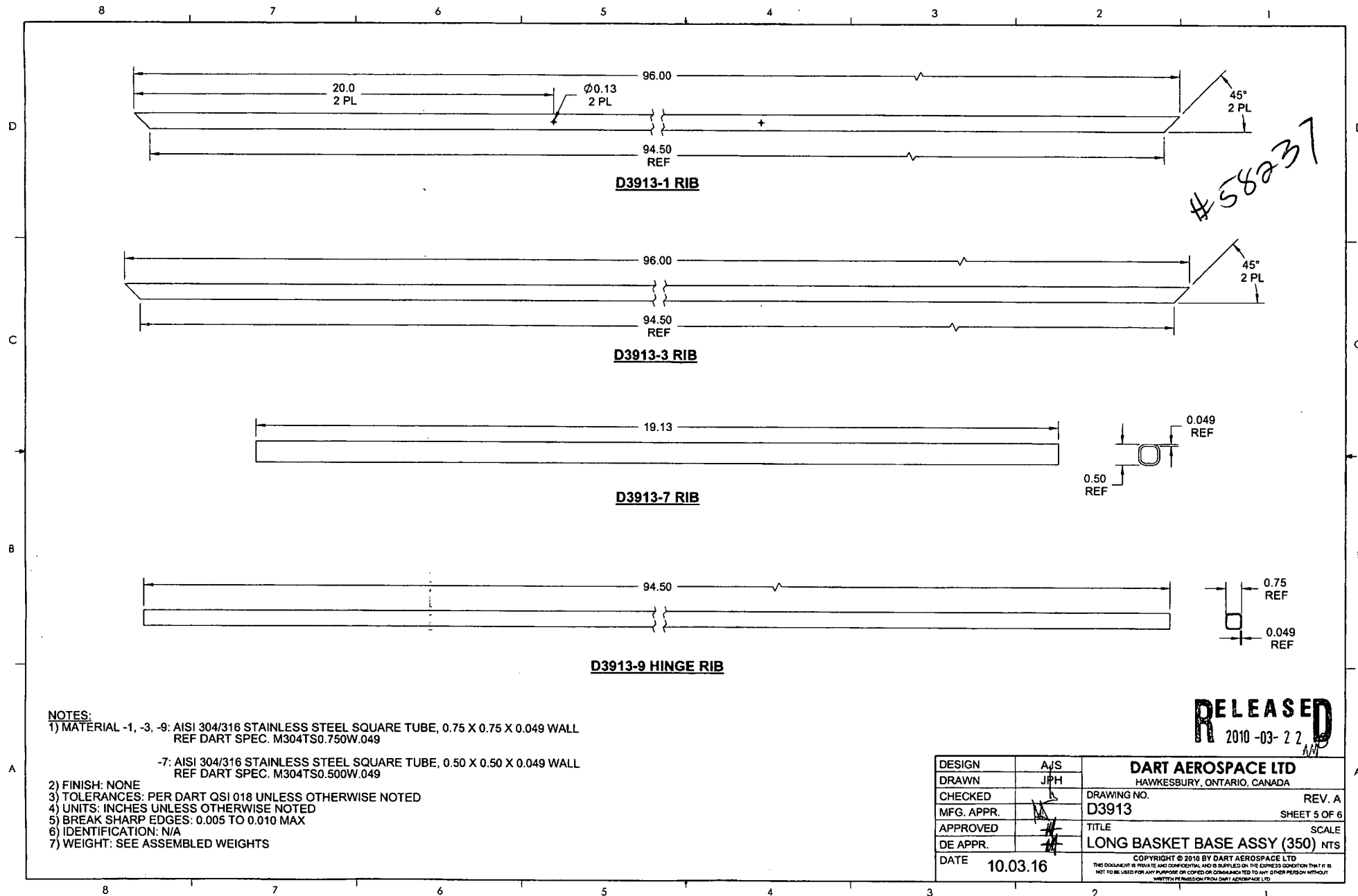
[8] D3913-101 TUBULAR ASSY (350 SHORT BASKET)

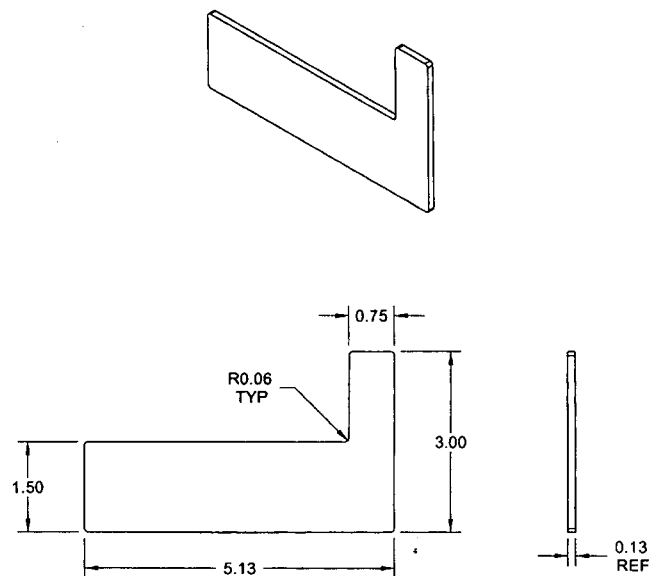
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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